

Work Order ID 79292

79292

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January-24-12 1:53:33 PM

Item ID: D3204-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Arm
 Start Date: 24/01/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 07/02/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 12/01/12 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3204	Rev A1								

100 0.00
100 BAND SAW
 Bandsaw Memo 0.00
 Jeaspa Bandsaw Cut blank: 1.25" x 0.375" x 3.370" long Bar (+0.030/-0.000)

110 0.00
110 HAAS CNC VERTICAL MACHINING #1
 HAAS 1 Memo 0.00
 HAAS CNC vertical machine #1 1- Machine as per Folio FA344 and Dwg D32042- DeburIdentify as D3204-5

120 0.00
120 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00
 Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: <u>W2</u>	0.00							
140									
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

OK 12/02/10

12

12/2/10 (12)

12/2/13

12-02-10 (12)

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Picklist Print

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Work Order ID: 79292

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Parent Item: D3204-5

D3204-5

Parent Item Name: Arm

Start Date: 24/01/2012

Required Date: 07/02/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: C05.08.11Added Step 25 KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.375X01.25 0		Purchased	No			100	f	23.4072	0.2913	3.679579			

M6061T6B0 375X01 250

**

6061-T6 Bar .375 x 1.25

Location

Loc Qty

Loc Code

MAT001

11.4072

110167

1.8602

110908

9.547

MAT002

12

120243

12

3.6 36 12/02/09

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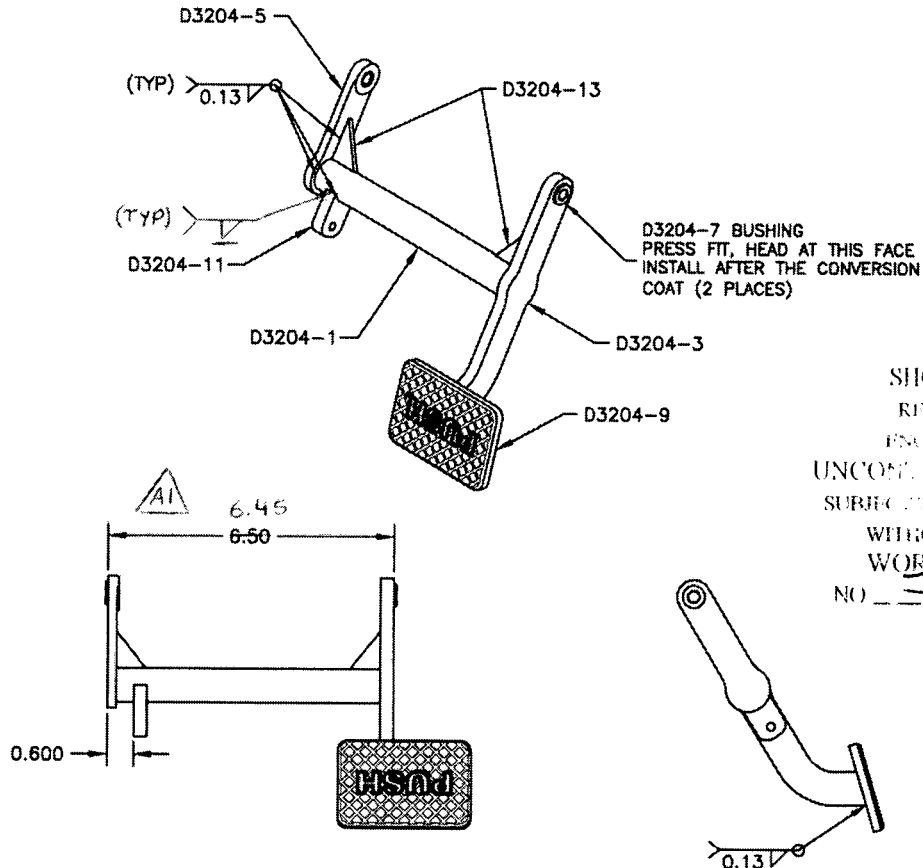
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DESIGN 4	DRAWN BY H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3204	REV. A SHEET 1 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS
A	04.01.27	NEW ISSUE	
AI	05.07.15	6.45 WAS 6.50	

RELEASED
04.04.30



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 79292
M.C.J.
12/01/24

D3204-041 RELEASE PEDAL ASSEMBLY

NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

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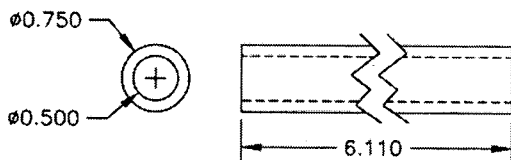
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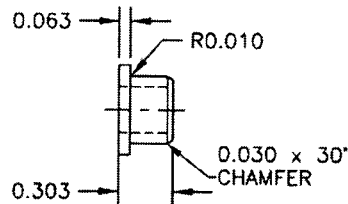
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3204	REV. A SHEET 2 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

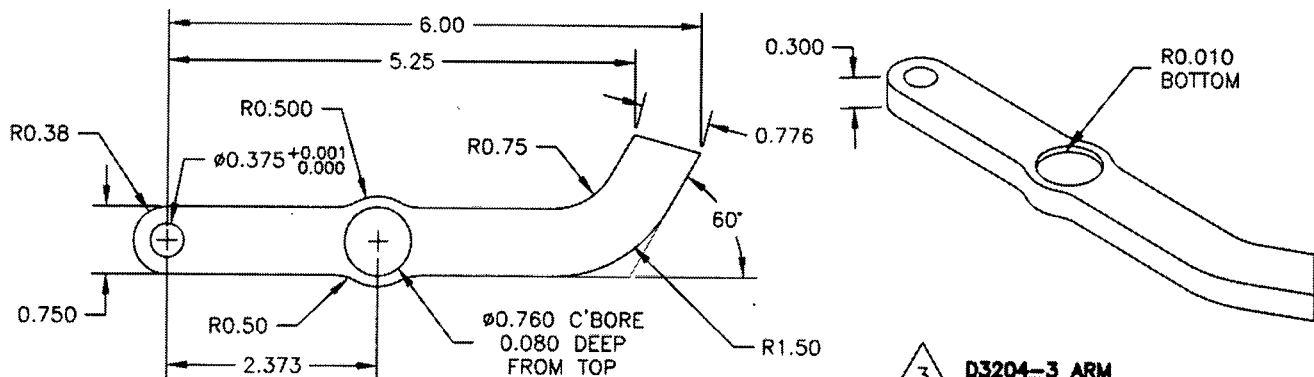
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04.04.05 #



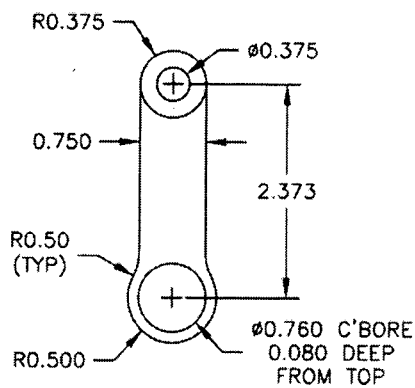
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SCALE 1:2



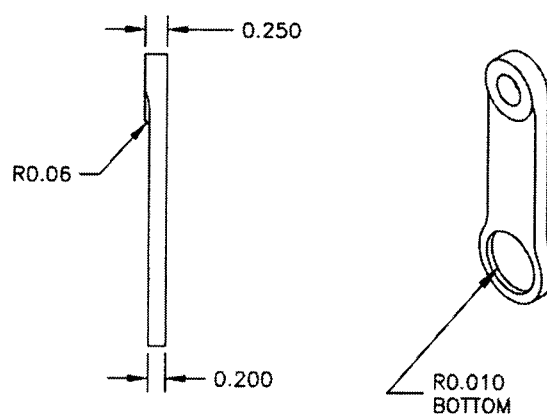
4 D3204-7 BUSHING
SCALE 1:1



3 D3204-3 ARM
SCALE 1:2



3 D3204-5 ARM
SCALE 1:2



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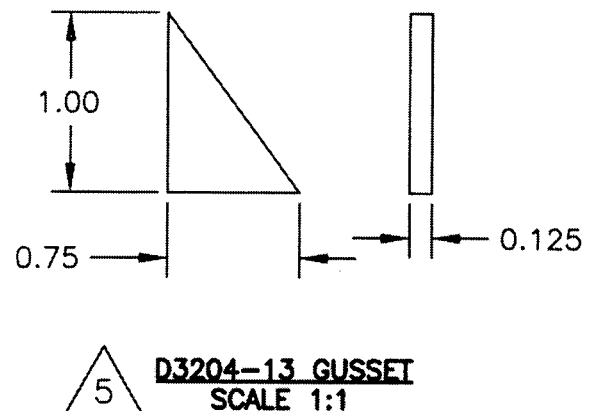
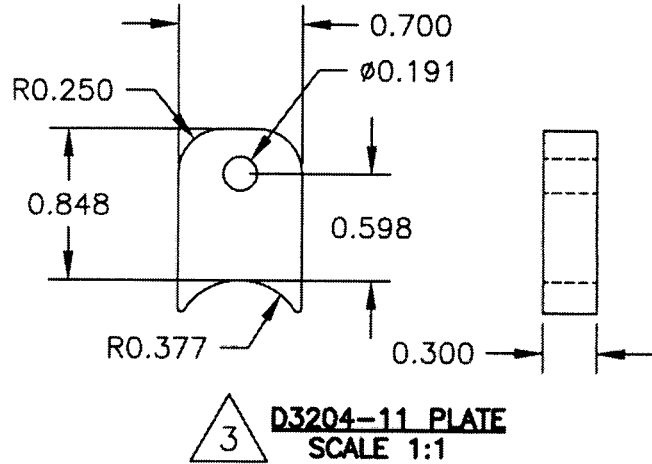
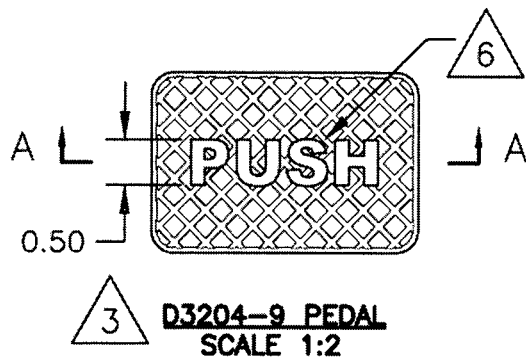
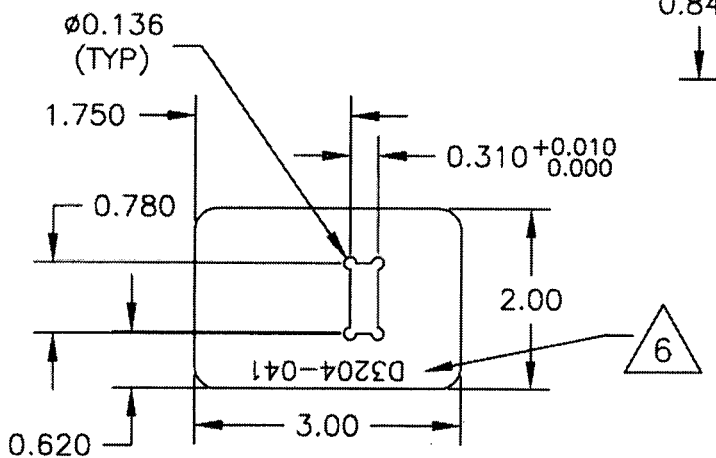
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DATE 04.01.27	TITLE RELEASE PEDAL ASSEMBLY		SCALE NTS

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